

Date: Friday, 7/4/2008 12:48:24 PM
User: Kim Johnston

Process Sheet

| | |
|---|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEARPAD |
| Job Number : 40275 | |
| Estimate Number : 10313 | |
| P.O. Number : | Part Number : D26483 |
| This Issue : 7/4/2008 S.O. No. : | Drawing Number : D2648 REV D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : D |
| Previous Run : 34591 | Material : |
| Written By : | Due Date : 7/30/2008 Qty: 30 Um: Each |
| Checked & Approved By : <u>0807</u> | |
| Comment : Est: E 02:09.18 Re-format, Incorporated D2648-1 KJ/RF | |
| Est Rev:F Now on Waterjet 06-08-14 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------|-------------------------|
| 1.0 | M1010S16GA | 1010/1025/A21/6aA SHEET |
|-----|------------|-------------------------|



Comment: Qty.: 0.0788 sf(s)/Unit Total : 2.3625 sf(s)
1010/1025/A21/6aA SHEET
(M1010S16GA)
Batch: 105706 B 8-7-21

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
1-Cut as per Dwg D2648
*****CUT WITH FILE D2648-1*****
Dwg Rev: D B 8-7-21
Prog Rev: D
2-Deburr if necessary B 8-7-21

33

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

508/2/01 (K38)

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

a/a Done at step 22
Cost 621

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:48:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 40275

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SB 08/07/24 (33)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R560Hardcoat

M106762

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

EL 8-7-24 (33)

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

PD 08-07-24

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/24 (33) counts

10.0

POWDER COATING

POWDER COATING



M 106442



(33X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30
320 OF
10:00

M-L 08/07/26

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-07-28 (33)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

FL 02/17 08-07-28 (33)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:48:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 40275

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/29 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-28

Dart Aerospace Ltd

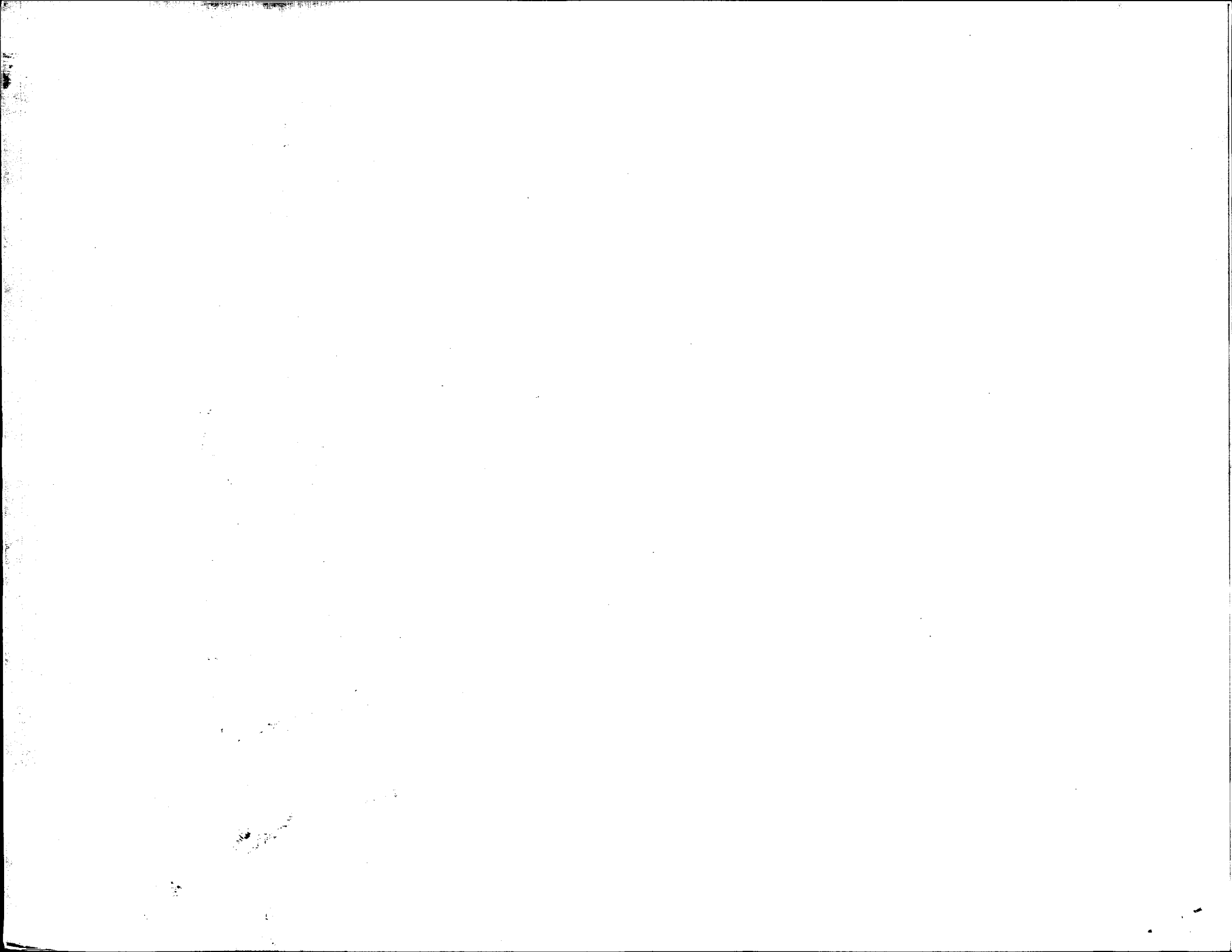
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

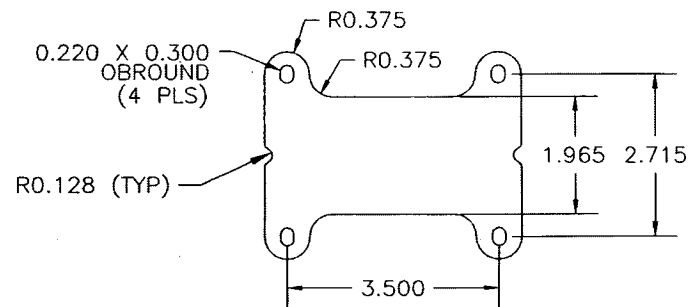
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

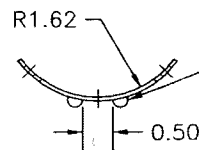
NOTE: Date & initial all entries



D2648-1 FLAT PATTERN

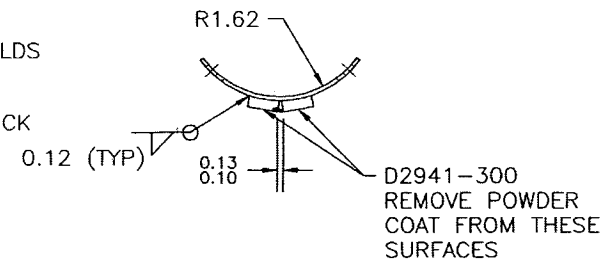


SECTION A-A

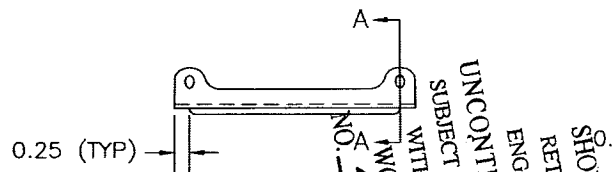


7560 HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

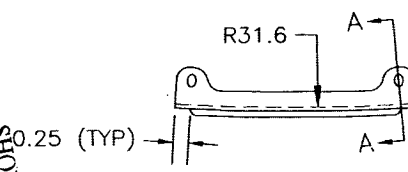
SECTION B-B



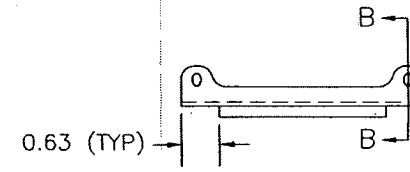
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED
99.12.20 DS



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
NO. 40275
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE

| | | |
|----------|----------|---|
| D | 99.11.17 | ADDED D2648-7 |
| C | 97.06.26 | R31.6 WAS R19.6 |
| B | 97.05.30 | ENLARGE OBOUND, 0.375 WAS 0.250 |
| A | 97.03.25 | NEW ISSUE |
| DESIGN | DRAWN BY | DART DART AEROSPACE USA, INC. BELLEVUE, WA |
| CHECKED | APPROVED | DRAWING NO. D2648 |
| DATE | | TITLE WEARPAD |
| 99.11.17 | | REV. D SHEET 1 OF 1 SCALE 1:2 |